

5/12

| | | |
|---|--------------|---------|
| DART AEROSPACE LTD | Work Order: | 22784 |
| Description: 206 L/L-1/L-3/L-4 HighGear Web | Part Number: | D2654-7 |
| 04.03.17 F8 04.03.17 QP Drawing: D2654 Rev. D/E1 | Qty: | 2 |

| Step | Location | Procedure | By | Date | QTY |
|------|------------|---|----|----------|-----|
| 1 | EXPEDITING | Issue Work Order | PF | 05.03.21 | (2) |
| 2 | METAL | Pick: Qty Part Number Description Batch 1 D2600-7 Web B21130 | PF | 05-3-23 | (2) |
| 3 | METAL | Cut D2600-7 to length as per Dwg D2654 (+16.00") 04.03.17 QP | PF | 05-3-23 | (2) |
| 4 | METAL | Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654 | PF | 05-3-23 | (2) |
| 5 | METAL | Using the uni-bit, open holes to finish size as per Dwg D2654 | PF | 05-3-23 | (2) |
| 6 | METAL | Deburr holes and ends | PF | 05-3-23 | (2) |
| 7 | METAL | Acid Etch and Alodine as per QSI 005 4.1 | PF | 05-3-30 | (2) |
| 8 | QC | Inspect Level 5 | PF | 05-03-30 | 2 |
| 9 | METAL | Identify and stock | PF | 05/3/30 | (2) |
| 10 | EXPEDITING | Close Work Order Cost/part: 41.14 \$45 05/04/01 (2) 16.38 | PF | 05.04.05 | (2) |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-------------------------------|------------|----------|
| A | 97.07.30 | New Issue | JB | |
| B | 97.08.28 | Change part No. Step 1 & 2 | KS | |
| C | 98.09.14 | Re-format, drawing rev. | CS | |
| D | 99.02.04 | Fixed typo, Changed procedure | DM | (S) |

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
DM 99.02.19

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|-----------------------|----------------------------------|----------------|--|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

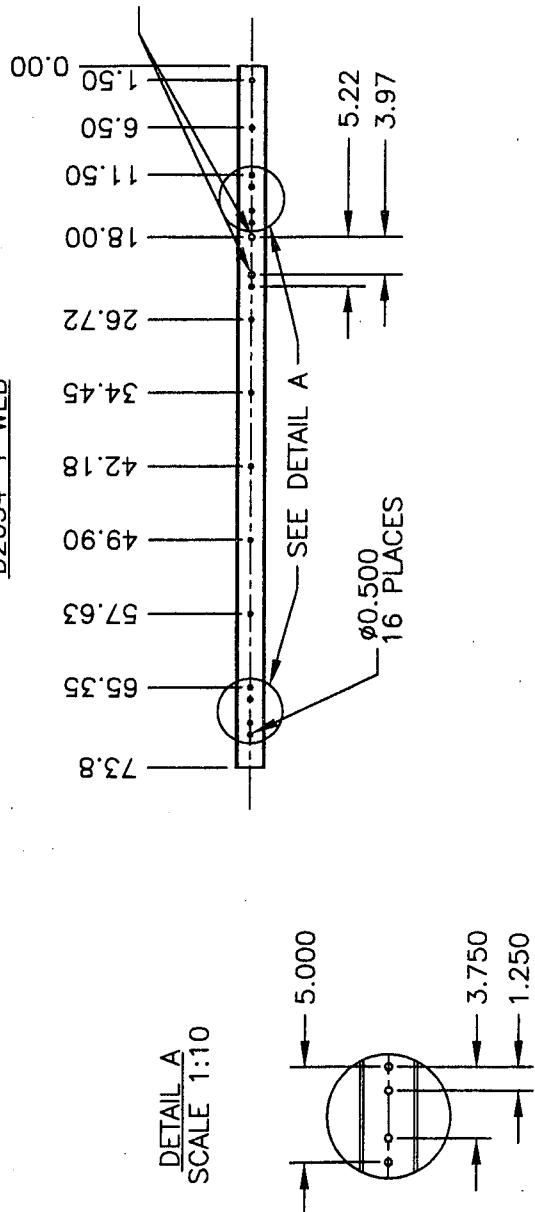
QA: N/C Closed: _____ Date: _____

DARTOF COPY IS
ONE

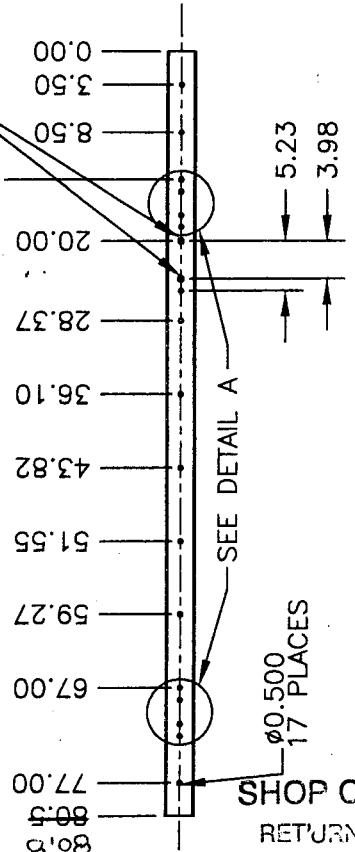
| | | |
|----------|----------|--|
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D2654 REV. E SHEET 1 OF 2 |
| DATE | | SCALE 1:20 |
| 04.05.26 | | WEB |
| A | 97.03.25 | NEW ISSUE |
| B | 97.06.26 | ALTER HOLE PATRN., 0.500 WAS 0.438 |
| C | 97.10.29 | CHANGED HOLE PATTERN |
| D | 98.01.15 | GHW HOLES CHANGED TO $\phi 0.63$ |
| E | 04.05.26 | CHANGE LENGTHS, REFORMAT |
| E1 | 04.08.04 | PER TOOLING; 80.8 WAS 80.5 |

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22784

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

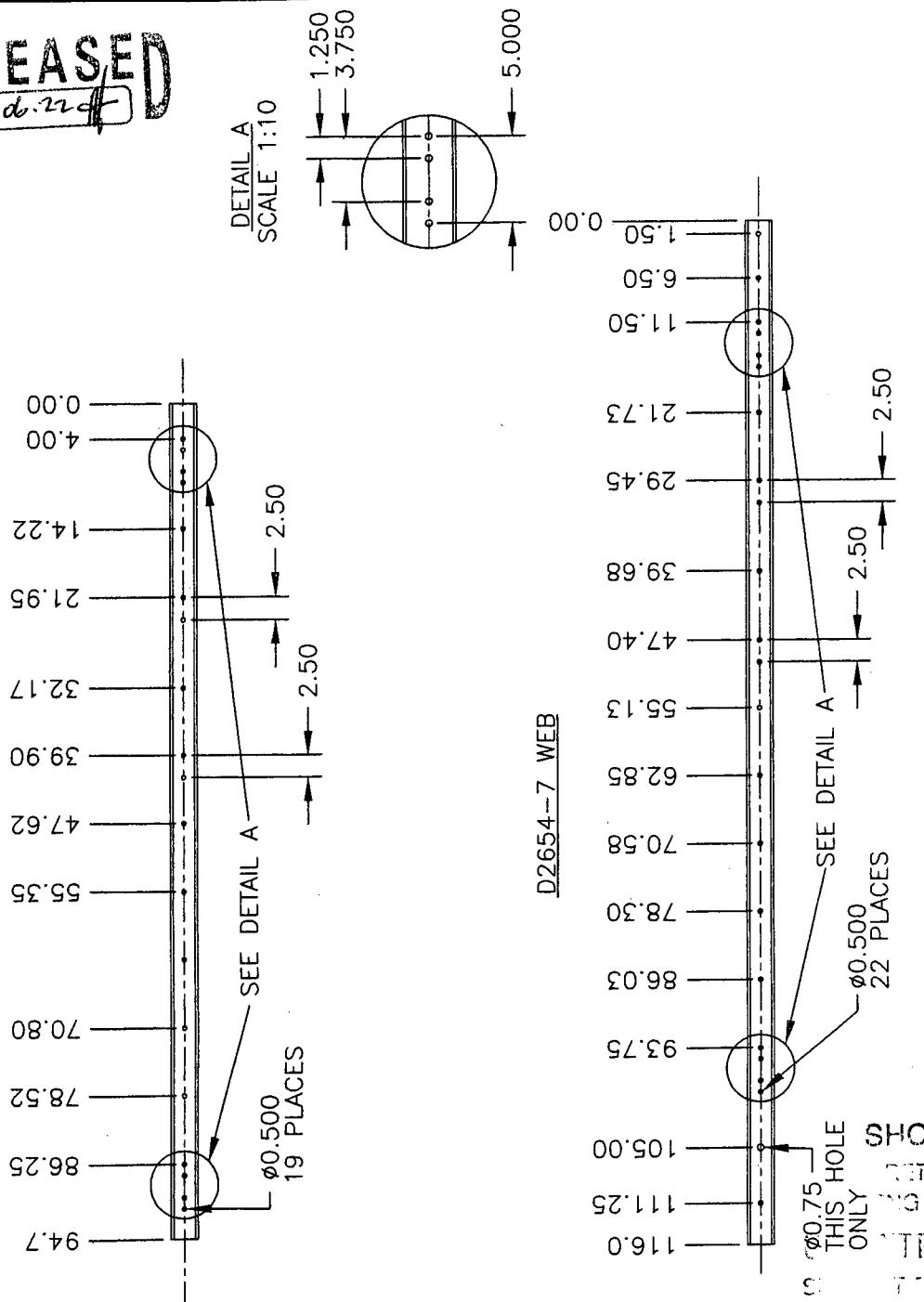


| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>IP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>TH</i> | APPROVED <i>TH</i> | DRAWING NO. D2654 | REV. E SHEET 2 OF 2 |
| DATE 04.05.26 | TITLE WEB | | SCALE 1:20 |

RELEASER
04.06.22 ~~CH~~

04.06.22 d

D2654-5 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS HOLE
ONLY
SHOP COPY
RETURN TO
ENGINEERING
UNTRACED COPY
FOR AMENDMENT
HOLD NOTICE

WORK ORDER
NO. 22784

Copyright © 1997 by DART AEROSPACE USA, INC.

Copyright © 1997 by DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Job Costing Report

Dart Aerospace Ltd.
HawkesburyMar 21, 2005
10:23 am

Work Order No : 0022784
 Project Name : D2654-7
 Project For : WK512
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2654-7
 Description : 206 I Beam (Web)
 Manufactured : Yes
 Amount Req'd : 2
 Amount Done : 0
 Start Date : 03-18-05
 Est Finish Date : 03-25-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| ===== | | ===== | ===== | | |
| Burden : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| ===== | | ===== | ===== | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/ (Loss) : | 0.00 | 0.00 |